

Rush need by July 14th latest
Dart Aerospace Ltd.

Date: Tuesday, 04/07/2006 11:44:27 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FITTING
Job Number	: 27759		
Estimate Number	: 10870		
P.O. Number	: NIA	Part Number	: D32163
This Issue	: 04/07/2006 S.O. No. : NIA	Drawing Number	: D3216 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 28/06/2006 Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	:	Material	: NIA
Written By	: SEE COMMENT BELOW	Due Date	: 12/07/2006 Qty: 12 Um: Each
Checked & Approved By	: <u>W</u>		
Comment	: Est: A 03.10.28 New Issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 .125 Sheet
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Comment: Qty.: 0.0288 sf(s)/Unit Total : 0.3456 sf(s)
304/316 .125 Sheet

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

Tumble until parts have a polished finish.

6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Date: Tuesday, 04/07/2006 11:44:27 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 27759

Part Number: D32163

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Sty 16*

Rec'd 13 (12)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.14

Job Completion



U 06.07.14

Date: Wednesday, 6/28/2006 4:18:48 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 27759
 Estimate Number : 10870
 P.O. Number :
 This Issue : 6/28/2006 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : PURCHASED PARTS
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est: A 03.10.28 New Issue KJ/RF

Drawing Name : FITTING

Part Number : D32163
 Drawing Number : D3216 REV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 7/12/2006

See replacement
 w/o attached

Qty: 12 Um: Each

Additional Product

Job Number:

Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING

Comment: PURCHASING

Issue P/O:

Email or Ship DXF file to vendor

Laser Cut D3216-3 Fitting as per Dwg D3216.

Material release note is required

MATERIAL
 (in 3015025)
 (.0288 SF)

BATCH:

M101463

M 06 07 07

2.0 D32163F Fitting

Comment: Qty: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Fitting

M

06 07 07

(12)

3.0 PACKAGING+ QC2 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

M

06 07 07

(12)

(10)

(12)

4.0 QC6 QC8 DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK

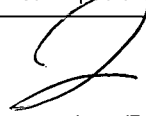
06-07-07

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

Tumble until parts have a polished finish.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-07-07	4	QC & for second check. Permanent Change					 06-07-07

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/28/2006 4:18:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 27759

Part Number: D32163

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

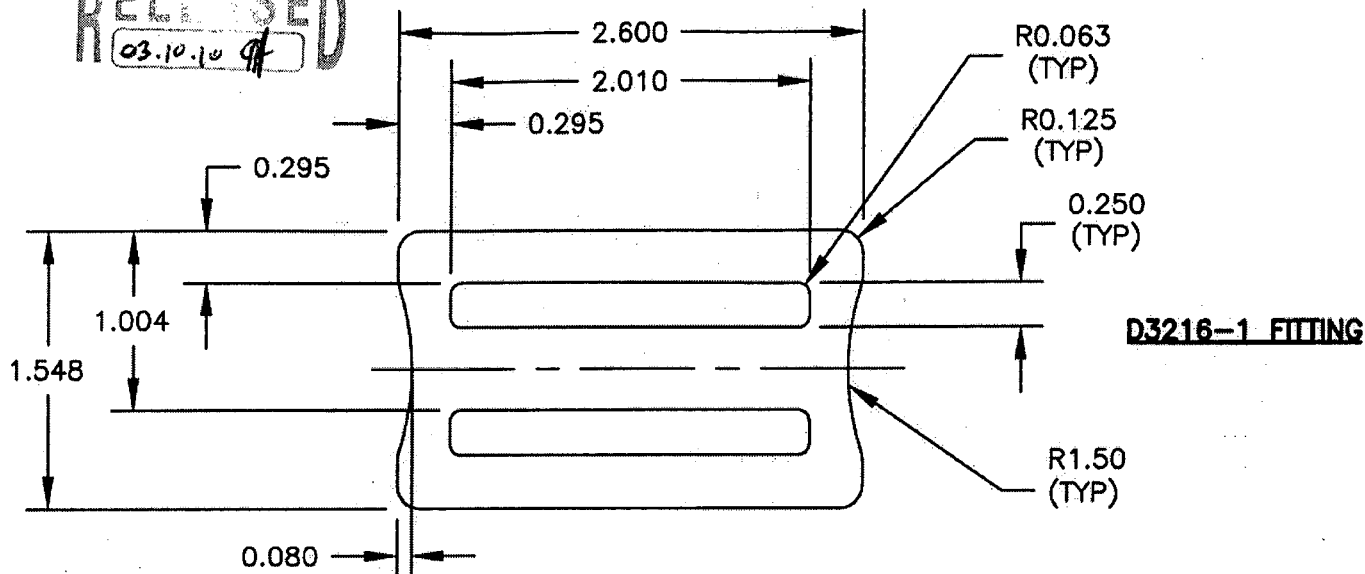
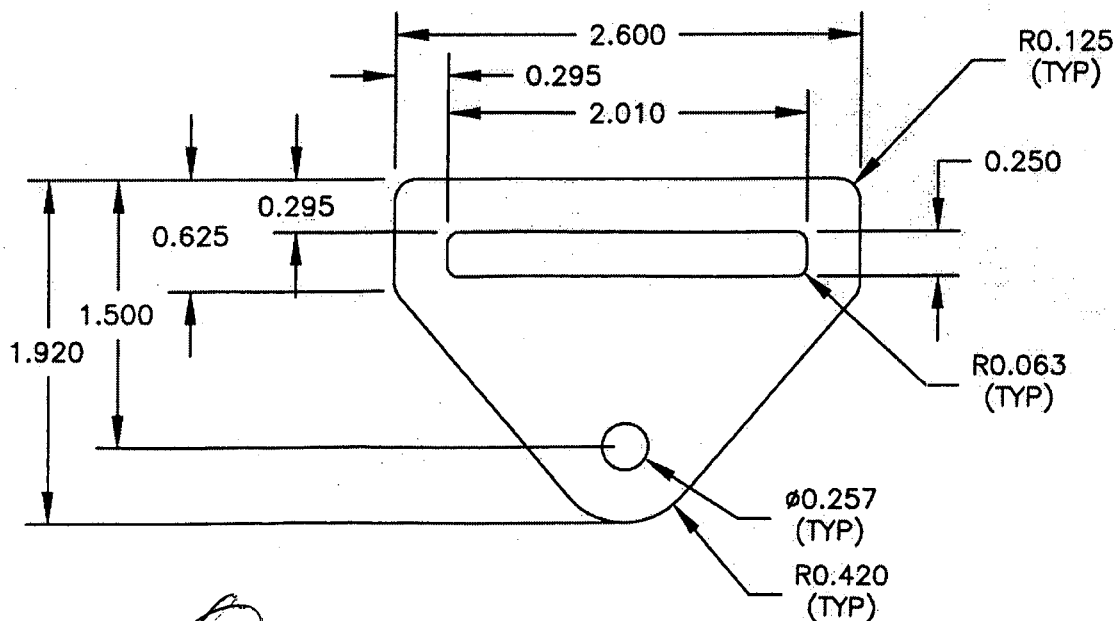
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3216	REV. A SHEET 1 OF 1
DATE 03.09.26		TITLE FITTING	SCALE 1:1
A	03.09.26	NEW ISSUE	

RELEASED
03.10.10 *[Signature]***D3216-1 FITTING****D3216-3 FITTING****D3216-1/-3 FITTING**

- 1) MATERIAL: AISI 304/316 PLATE, 0.125 THICK (REF DART SPEC. M304S11GA)
- 2) FINISH: MOLECRO POLISH
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27759

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